

5/3

DART AEROSPACE LTD	Work Order:	22792
Description: Doubler	Part Number:	D3302-3
Dwg: D3302 Rev. A 04.03.25 04.03.25	Qty:	20/10 Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	JL	05.03.22	20/10
2	MV	Cut blank: 14.300" x 9.100" 14.550" Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3302-3 Batch: M16455	EP	05/03/23	10
3	MV	Machine as per Folio FA450 and Dwg D3302 Stack of 10 Identify as D3302-3	EP	05/03/23	10
4	QC2	Inspect parts as they come off the CNC machine	EP	05/03/23	10
5	QC8	Second check	ML	05/03/23	10
6	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	Z	05.03.24	10
7	GB	Form as per Dwg D3302	Z	05.03.24	10
8	QC5	Inspect work to Step 7	10	05.03.24	10
9	FP	Chemical Conversion Coat as per QSI 005 4.1	CL	05/03/24	10
10	QC3	Inspect Chemical Conversion Coat	U	05/03/24	10
11	ST	Identify and Stock	CL	05/03/24	10
12	AC	Cost / part 11.57 19.29	SAC	05.03.24	10
13	DC	Close W/O 11.25 Inspect Level 21	JL	05.03.24	10

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	JL

RELEASED
04/09/02

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/03/23	# 3	first stack moved in Dowels.	R parrot	Screw & replace	EP 05/03/23	R 05/03/23	R parrot	R 05/03/23
05/03/23	3	only enough Mat. to make 10 parts.						

Part No: D3302-3

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA: 

Date: 05/03/24

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

DART AEROSPACE LTD

Work Order:

22792

Description: Doubler

Part Number: D3302-3

Inspection Dwg: D3302

Rev: ~~AB~~ 01/27/12

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Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:

Audited by:

Prototype Approval:

NA

Date: 05/03/23

Date: 05/03/23

Date: N/A

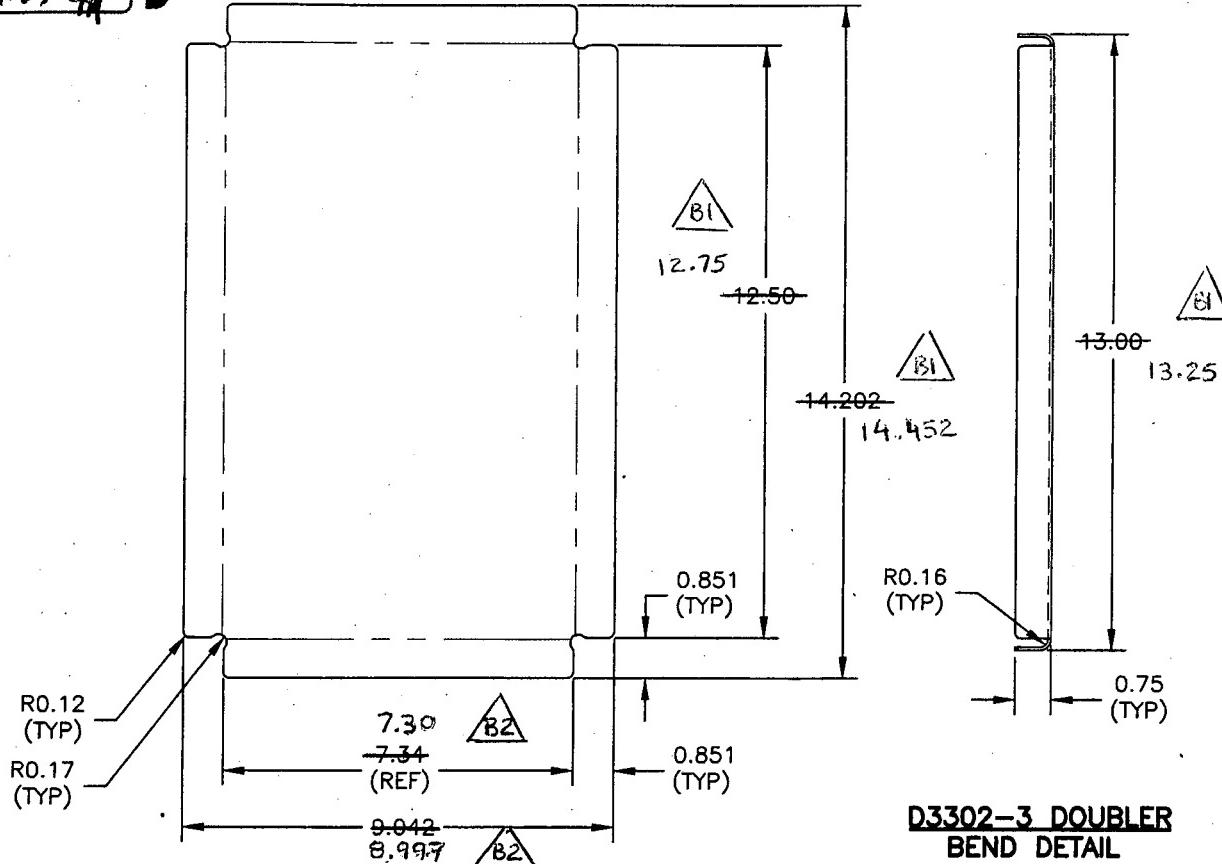
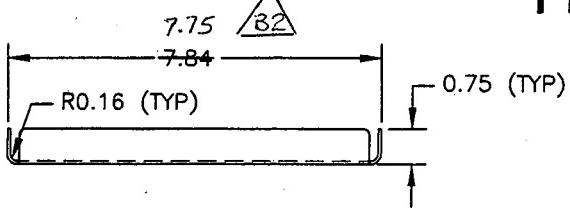
Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	<i>[Signature]</i>

H:\FORMS\Quality Assurance\approved QA\FAI revD

RELEASED
2017-09-07

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3302	REV. B SHEET 2 OF 4
DATE 04.11.18	TITLE DOUBLER	SCALE 1:4	

RELEASED
04.11.23 *[initials]***D3302-3 FLAT PATTERN****PRELIMINARY ISSUE****D3302-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S:063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 21, 2005
10:23 am

Work Order No : 0022792
 Project Name : D3302-3
 Project For : WK513
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3302-3
 Description : Doubler
 Manufactured : Yes
 Amount Req'd : *2010u*
 Amount Done : 0
 Start Date : 03-21-05
 Est Finish Date : 03-30-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00